

ing the gun or adjusting it horizontally. These separators have twenty-four holes, and opposite holes must be in alignment and in a radial position, as otherwise there will be a creeping action of the rollers relative to their bearing rings or tracks. A milling machine equipped with a simple type of indexing fixture is used for this work. The base *A* of the fixture is bolted to the machine table and the upper part *B* is free to revolve. This revolving member has accurately spaced holes which are engaged by indexing plunger *C*. After the holes have been

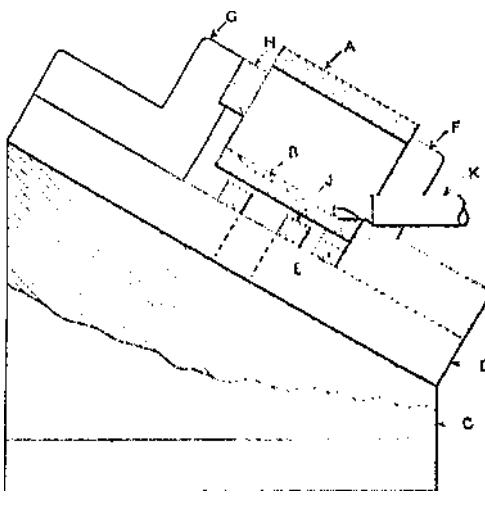
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Fig. 12. Detail View of
Milling Fixture <shown in
Fig. 1*t*

drilled and reamed, they are countercbored by tin* use* of suit-able tools. The separator rings are located on the fixture by means of the central bore.

Indexing Fixture for
Milling Clutches, *The*

design and construction of a special form of fixture used, for cutting the clutches on transmission drive pinions and sliding gears is shown in Fig. 14. This fixture consists of a frame *A* into which the spindle *B* is fitted. The spindle is designed to serve as a collet chuck on the upper end and is arranged to carry the large index plate *C* at its lower end. The index plate has a series of holes *E* drilled in it at a convenient angle to receive